

Date: Wednesday, 7/11/2007 3:05:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 33510A	
Estimate Number : 10375	
P.O. Number : <u>N/A</u>	Part Number : D30651
This Issue : 7/11/2007	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : B
Previous Run : 32032A	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 7/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 250 Um: Each
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Est:D 06.04.25 Water jet	EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

ISSUE P.O TO GFI 4149 07/07/12 (250)
 CUT AND FORM PER DRWG D3065 REV.B

2.0	D30651	Step Spacer
-----	--------	-------------



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
 Step Spacer

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 RECEIVE AND INSPECT FOR TRANSIT DAMAGE
 ENSURE MATERIAL CERTIFICATION IS ATTACHED

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

07/08/16 (260)
07/08/16 (X250)
07/09/28 (250)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 01/09/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:50 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 33510A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/ 07/09/07

250

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

7/10/09
QSP019

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 07/09/24

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(250)

Comment: FINAL INSPECTION/W/O RELEASE

7/10/09/24

Job Completion



U 07-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

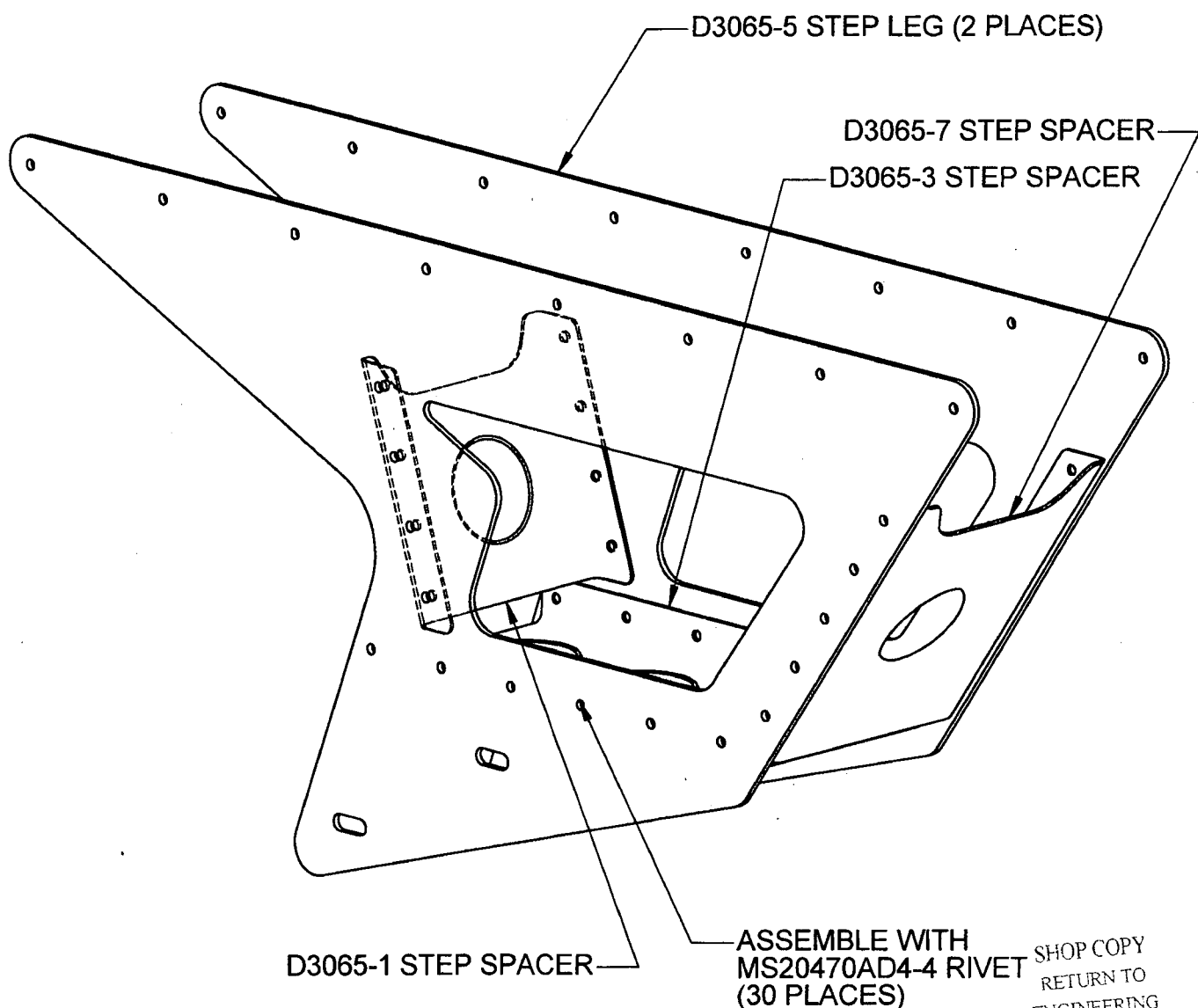
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

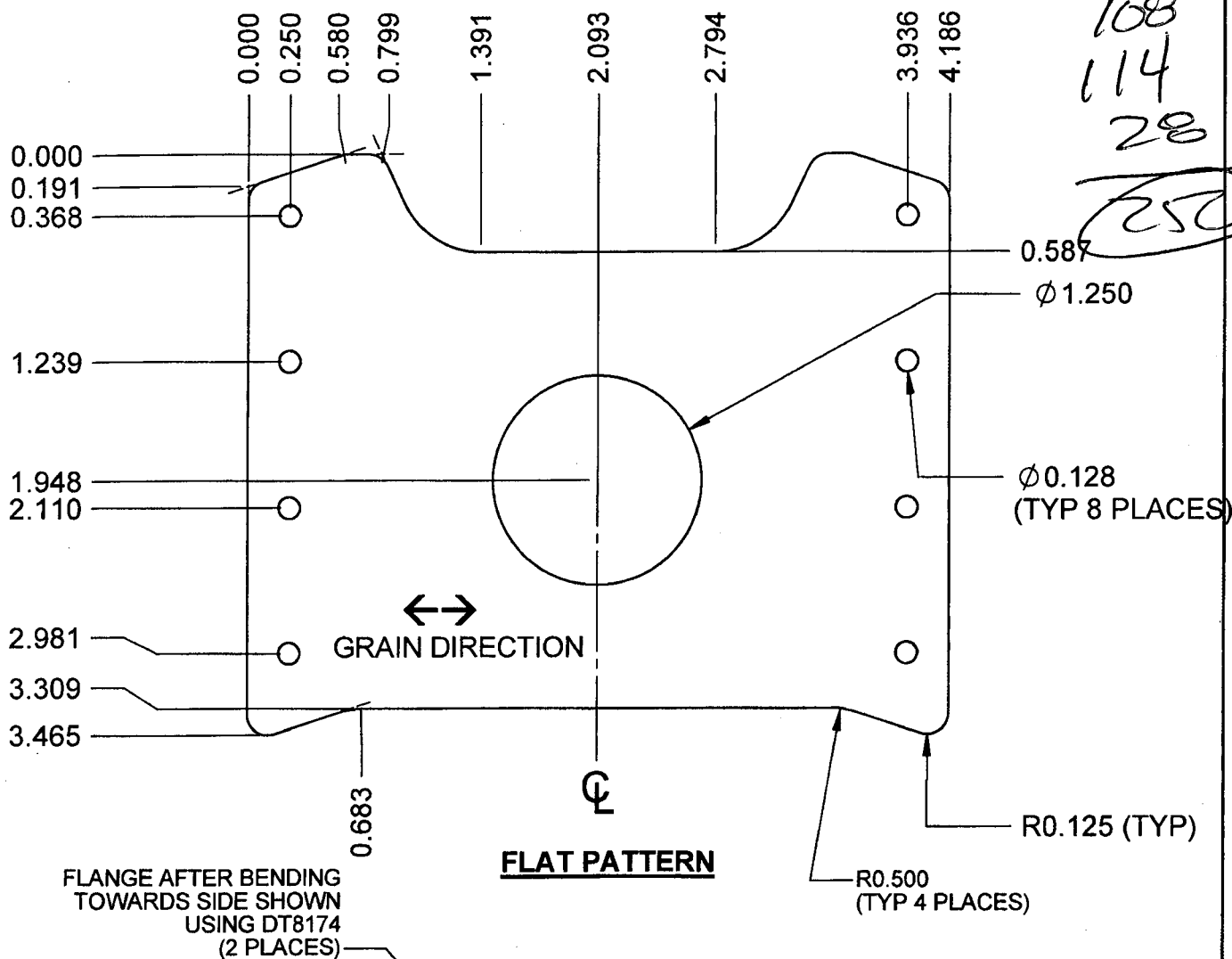
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NO. 33510A

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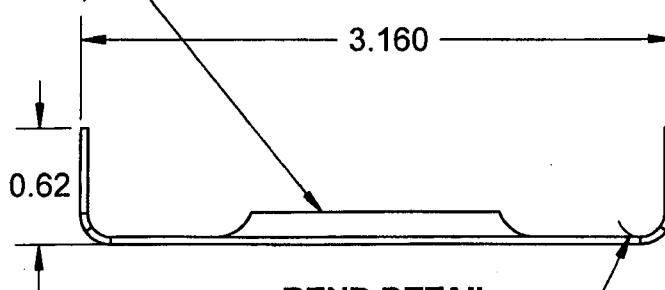
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



108
114
28
250

RELEASED

de de-ro



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

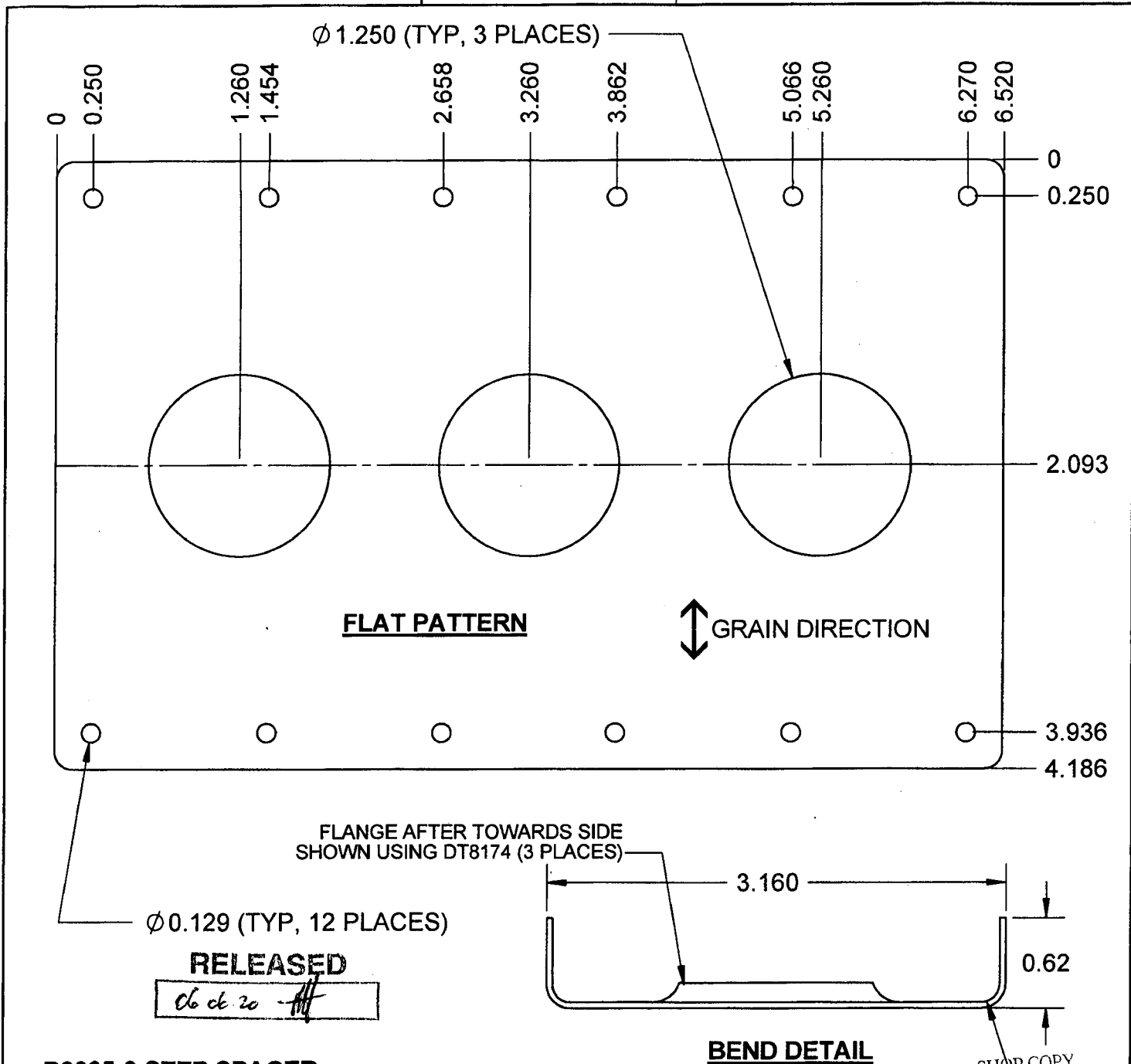
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

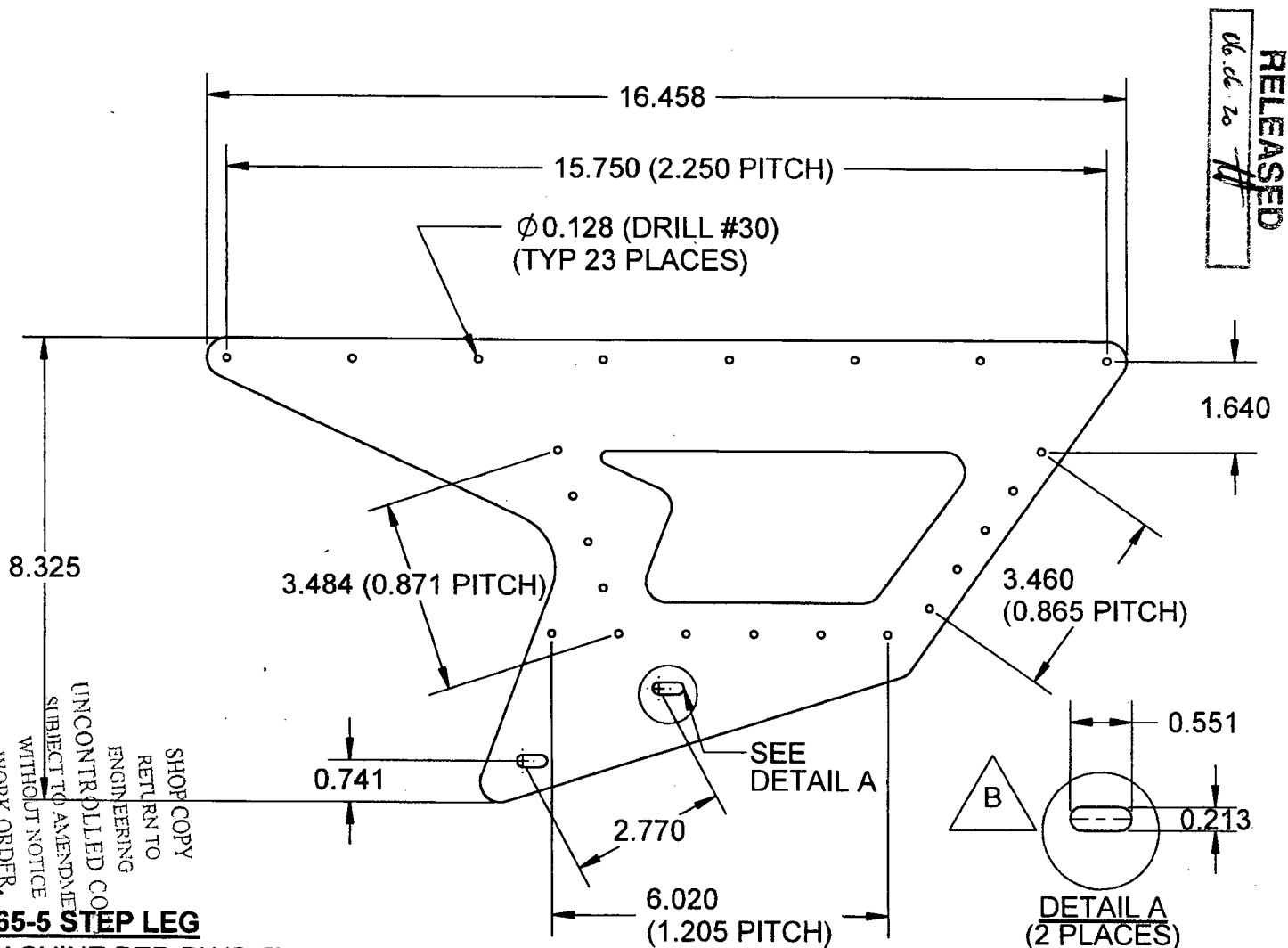
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DART

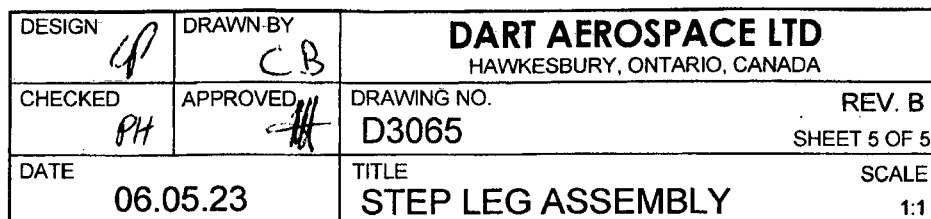
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
C.P.	C.B.	DRAWING NO.	REV. B
CHECKED P.H.	APPROVED P.H.	D3065	SHEET 4 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:3	

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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FLAT PATTERN

RELEASED

OK OK 20 ~~11~~

BEND DETAIL

R0.125 (TYP)

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

125 (TYP)
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WORK ORDER
NO. 33510A

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JUN. 19. 2007 4:20PM

GFI 514-630-4849

NO. 2128 P. 1



Member of / A member of Thomas-Betts

Non
Address: DART AEROSPACE
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

Date: 2007-06-19

Reference: D3065

GFI Quote: B 6646-rev A

Attention: LINDA LACELLE
Tel: (613)632-9577

Fax: (613) 632-1053

In reply to your request for quotation, we take pleasure in quoting the following parts:

Part/Drawing Number	Description	QUANTITY	PRICE EACH
D3065-1	LEG ASSY	250	€ 36\$
		500	€ 10\$
D3065-3	LEG ASSY	250	7.29\$
		500	7.05\$
D3065-5	LEG ASSY	250	10.09\$
		500	9.90\$
D3065-7	LEG ASSY	250	10.00\$
		500	8.85\$
	MATERIEL PUNCH and BEND INCLUDED LIGHTENING HOLE		
	FINISHING ARE NOT INCLUDED		
	LIGHTENING HOLE tooling by DART <i>send tooling</i>		

GENERAL NOTES:

- Delivery 4 weeks
 - Quote is valid 30 days.
 - Payment terms: Net 30 days
 - Freight: FOB our plant.
 - Federal and Provincial taxes are not included. This quotation is based on documents in our possession. Any changes or omissions can modify our price.
- Due to the fluctuating costs of raw materials in the present market, prices stated in the quotation above are subject to change. Purchase orders may be subject to price revisions before acceptance.

PEDRO MENDEZ 2007-06-18

Member of / A Member of **Thomas & Betts**

Non Address: DART AEROSPACE
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

Date: 2007-06-15

Reference: D3065

Attention: LINDA LACELLE
Tel: (613)632-9577

GFI Quote: B 6646

Fax: (613) 632-1053

In reply to your request for quotation, we take pleasure in quoting the following parts:

Part/Drawing Number	Description	QUANTITY	PRICE EACH
D3065-1	LEG ASSY	250	5.00\$
		500	4.78\$
D3065-3	LEG ASSY	250	6.36\$
		500	6.14\$
D3065-5	LEG ASSY	250	10.09\$
		500	9.90\$
D3065-7	LEG ASSY	250	5.71\$
		500	5.19\$
	MATERIEL, PUNCH and BEND INCLUDED		
	LIGHTENING HOLE and FINISHING ARE NOT INCLUDED		

GENERAL NOTES:

- Delivery 4 weeks
 - Quote is valid 30 days.
 - Payment terms: Net 30 days
 - Freight: FOB our plant.
 - Federal and Provincial taxes are not included. This quotation is based on documents in our possession. Any changes or omissions can modify our price.
- Due to the fluctuating costs of raw materials in the present market, prices stated in the quotation above are subject to change. Purchase orders may be subject to price revisions before acceptance.

PEDRO MENDEZ 2007-0615

514 630 4849

L Lacelle

From: L Lacelle [llacelle@dartaero.com]
Sent: June 18, 2007 9:06 AM
To: Pedro Mendez (Pedro Mendez)
Subject: D3065 your quote B 6646
Importance: High

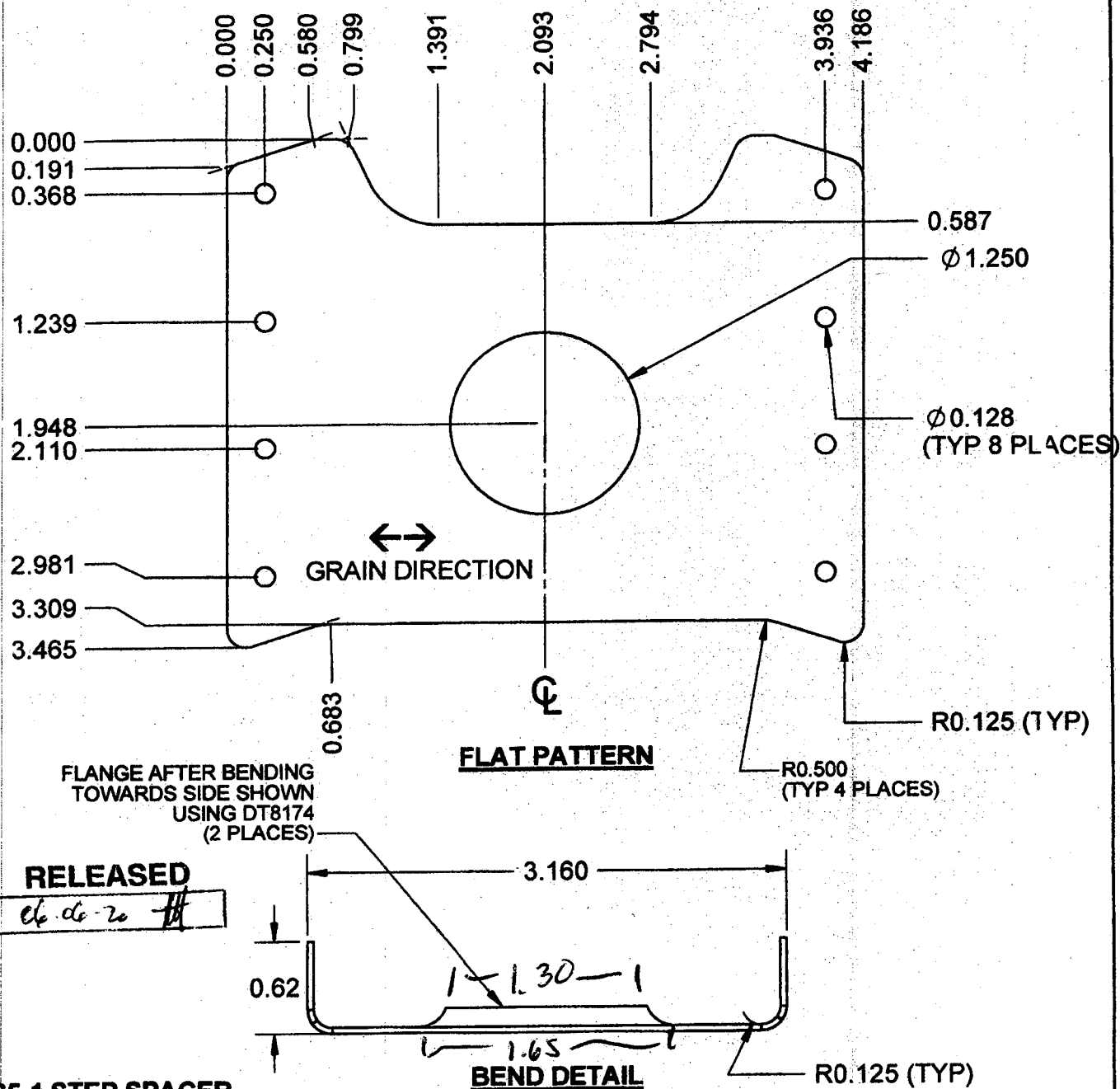
Hi Pedro,
What would be the price adder if you were to flange the holes on dwgs D3065-1/-3/-7 ? The size of the flanged hole is .130, we could send you our tooling.
We are very interested in giving you this order.

Thx
Linda

18/06/2007

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	F EV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Date: Friday, 15/06/2007 2:48:01 PM
User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 31794A	Customer	: Dart Helicopters Services
Estimate Number	: 10375	DWG Name	: STEP SPACER
Purchase Order #	:	Part Number	: D30651
Complete Date	: 11/06/2007 8:50:10	DWG Number	: D3065 REV. B
		Rev.	: B

DUE DATE	ORDERED	DELIVERED
15/05/2007	60	60

1.0	M2024T3S040-2024-T3 .040 sheet	INVENTORY ITEM
------------	---------------------------------------	-----------------------

DATE	EMPLOYEE	TYPE	Qty	COST	Lot #	Qty
07/05/2007	MURD02: Murdoch, Matthew	M2024T3S040	7.799	\$34.01	03321	8
Subtotal:	QTD:	0 CTD:	8	\$34.01		

2.0	WATER JET	Internal Operation
------------	------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
07/05/2007	MURD02: Murdoch, Matthew	Run	60.000	2.28	\$35.45	2.29	47.01
07/05/2007	DROU02: Drouin, Steven	Run	60.000	0.89	\$13.84	0.89	18.27
07/05/2007	DROU02: Drouin, Steven	Run	60.000	0.19	\$2.95	0.19	3.89
Subtotal:	QTD:	180 CTD:	0	3.36	\$121.41		

5.0	SMALL FAB 1	Internal Operation
------------	--------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
07/05/2007	FAUT01: Fauteux, Melanie	Run	60.000	0.20	\$3.11	0.20	4.11
Subtotal:	QTD:	60 CTD:	0	0.20	\$7.22		

6.0	BRAKE NC	Internal Operation
------------	-----------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
09/05/2007	BOUC01: Boucher, Sylvie	Run	0.000	3.26	\$50.69	3.26	66.91
14/05/2007	BOUC01: Boucher, Sylvie	Run	60.000	4.40	\$68.42	4.40	90.31
Subtotal:	QTD:	60 CTD:	0	7.66	\$276.33		

8.0	HAND FINISHING1	Internal Operation
------------	------------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
08/06/2007	LAUG01: Laughren, Gary	Run	0.000	0.00	\$0.00	0.63	16.39
08/06/2007	LAUG01: Laughren, Gary	Run	60.000	0.63	\$8.45	0.00	0.00
Subtotal:	QTD:	60 CTD:	0	0.63	\$24.84		

Total:				TIME	COST		
		Machine Time:		11.86	\$246.89		
		Labor:		11.85	\$182.91		
		Sub-contract (external Op.):			\$0.00		
		INVENTORY ITEM:			\$34.01		
		SUB-COMPONENT (SUB-JOB):			\$0.00		
					\$463.81		

COST PER UNIT: \$7.73

AU. 9.75



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2007/08/14	0371486

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO	N° COMMANDE PONO	VIA SHIP VIA
DART GFI-0299	J0165071	PO00004149	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO	DESCRIPTION	
250	D30651	STEP SPACER C OF C REQ'D <i>EP 07/08/16</i>	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO **J0165071** SHIPPING MEMO **0371486**

ITEM QUANTITY PURCHASE ORDER PART NUMBER REV NAME DWG ISSUE

250 PCS **PO00004149** **D30651** **B** **STEP SPACER** **B**

MATERIAL SUPPLIED BY MAT. REL. NO.

AL 2024-T3 (QQ-A-250/4) **SAMUEL / KAISER ALUMINUM** **H/N # 395420A3**

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **14 AUGUST 2007**

G.F.I. Q.C. REP. **Carlton H. H. H.**

LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 17 JUILLET 2007

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 71991

de commande SSMQ: 870053

Customer's order #:

SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
3	5	.040" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	395420A3

Bien à vous,
Yours truly,

Commis à l'administration.
Administration Clerk.



SHIP TO:
SAMUEL MISSISSAUGA
2360 DIXIE ROAD
MISSISSAUGA, ON, CA L4Y1Z7

SOLD TO:
SAMUEL LAVAL
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4089691

BL 100910

CUSTOMER PO NUMBER: N19210		WORK PACKAGE:		CUSTOMER PART NUMBER:			SHIP RUN/LOAD ID: 100910/6		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1047772	LINE ITEM: 5	SHIP DATE: 20-FEB-2007		ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: MILL FINISH_COIL			
WEIGHT SHIPPED: 2752 LB		QUANTITY: 1 PCS EST.		B/L NUMBER: 2011769		GAUGE: 0.0400 IN		WIDTH: 48.000 IN		LENGTH: 0.000 IN

Certified Specifications

AMS 4037/RevN
CMMP 019/RevD

AMS-QQ-A-250/4/RevA
CMMP 025/RevQ

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 395420A3 Cast 364 Drop 30 Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.2 : 68.6 (470 : 473)	46.9 : 47.1 (323 : 325)	17.5 : 17.6

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.20	4.49	0.53	1.28	0.01	0.22	0.02	0.01	0.00	TOT 0.06

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poynor